

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000980**Date Inspected:** 27-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Xiu Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 114 meter mock up, Floor beams for OBG**Summary of Items Observed:**

The Caltrans Quality Assurance (QA) inspector, Scott Croff, was present at Zhenhua Port Machinery Company, Ltd (ZPMC) to observe the scheduled mock up construction and production construction of the SAS Superstructure.

Upon the QA inspector's arrival, the QA inspector was directed to witness ultrasonic testing (UT) that was being performed by ZPMC technicians. The QA inspector went to the work location and was informed that all testing was finished.

The QA inspector observed heat straightening being conducted on MUSC-MA107. The QA inspector was informed the work was being conducted per the approved HSR(CT)-013. The QA inspector confirmed the approved HSR and work being conducted. The QA inspector noted that additional NDE will need to be conducted upon completion of heat straightening per section 11 of the approved welding quality control plan (WQCP) requirements.

As noted on the TL-6031 report from 11-26-2007, the QA inspector Robert Cuellar notified the QA inspector that a report of non-conformance should be written on the observed heat straightening of Floor beam components.

**Summary of Conversations:**

As noted above, the QA inspector Scott Croff was informed by ZPMC personnel that ultrasonic testing was finished and was informed of the HSR that was being used as it was observed by the QA inspector.

The QA inspector Scott Croff then spoke with the QA inspector Robert Cuellar and confirmed the approved

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HSR-013. The QA inspector Scott Croff was also informed that a report of non-conformance should be written regarding the reported observations from 11-26-2007. The QA inspector Scott Croff was given additional information regarding the NCR and information from the observations of the QA inspector Alfredo Acuna. There were no other notable conversations during this shift.



### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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| <b>Inspected By:</b> | Croff,Scott    | Quality Assurance Inspector |
| <b>Reviewed By:</b>  | Cuellar,Robert | QA Reviewer                 |

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